

Work Order ID 140538

140538

Page 1

Thursday, January 07, 2016 1:25:26 PM

Item ID: D2500-1-190

Accept

N900040100

Setup Start *NS1*

Revision ID:

DAS

Stop *NS2*

Item Name: Ext'n - I' Beam Tube 4"

13

9-89

Start Date: 1/7/2016 Start Qty: 40.00

40

JAN 15 2016

Cust Item ID:

Required Date: 1/7/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLS Date: JAN 07 2016

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2500	Rev H

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

DAS

13

9-89

JAN 15 2016

82

Purchasing

Issue P/O: 31027

- a) Extrude as per Dwg D2500
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 190" long
- g) Bon L Canada Inc. tool # 897105
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.01

Packaging

Ensure material certification is attached

918 Sp 16-03-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 140538

Thursday, January 07, 2016 1:25:26 PM

140538

Page 2

Item ID: D2500-1-190

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ext'n - I' Beam Tube 4"

Start Date: 1/7/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 1/7/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									5/16/03/24
QC	Memo	0.00							
Quality Control :	Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester								Pto 5
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.01							
Packaging	LOCATION LG002								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.07							
Quality Control									

9115 16-3-24

MLJ MAR 3 11 2016

SN 20160330

DQA:

Date: 16.05.10



QA Closed

Date: 16/04/15

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: 140538		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. D2500-1-190		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. 16-5703		Scrap ☒		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☒			
Date: 2016/03/24		Step #: 120		QTY Effective: 23				MRB (QSI042) Approval			
								15 2016/03/28			
Description Work Order Deviation				Disposition				Completed By			
Qty x 3 lengths of extrusion found to be acceptable. (2 too due to twists in crank and 1 due to dents) Re. Admin is.				Scrap + Destroy No need to contact supplier				16-3-30			
								Lead hand / Supervisor Approval Verification			
								16-3-30			
								QC / QA Coordinator Approval			
								15 2016/03/28			
Root Cause				FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☒	Cracks ☐	Broken/Damage/Defect ☒	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐										
Misidentified ☐	Past Due ☐	OTHER:									

Picklist Print

Thursday, January 07, 2016 1:25:29 PM

Page 1

Work Order ID: 140538

140538

Parent Item: D2500-1-190

D2500-1-190

Parent Item Name: Ext'n -'I' Beam Tube 4"

Start Date: 1/7/2016

Required Date: 1/7/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: G 02.09.05 Added DSK 066 KJ/RF
IPP: H 07.07.06 rev G dwg EC IPP Rev:I as per
dwg revH DD 10.02.23 verified byEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2500-1-190P

Purchased

No

110

Each

0.0000

1

D2500-1-190P

Ext'n -'I' Beam Tube 4"

**

40 9/1

9/1

Sp16-03-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

SPECIFICATION CONTROL DRAWING

D2500-1-XXX EXTRUSION & D2500-3-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D2500-1 = 0.143 lb/in, D2500-3 = 0.066 lb/in
- 8) FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG). D2500-1 EXTRUSION MANUFACTURED FROM:
 - A) BON L DIE # 897105 -> PREFERRED
 - B) CARADON MIDEAST DIE # PAH-28030
 - C) CARADON MTL DIE # MH-18868
- 9) FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG). D2500-3 EXTRUSION MANUFACTURED FROM:
 - A) CARADON INDALEX DIE # MS-18867

SHOP COPY

REVISION TO

ENGINEER'S

UNCONTROLLED COPY

SUBJECT TO AGREEMENT

WORK ORDER

NO. 140538 MLJ

1601-07

RELEASED
2010-02-03
MT

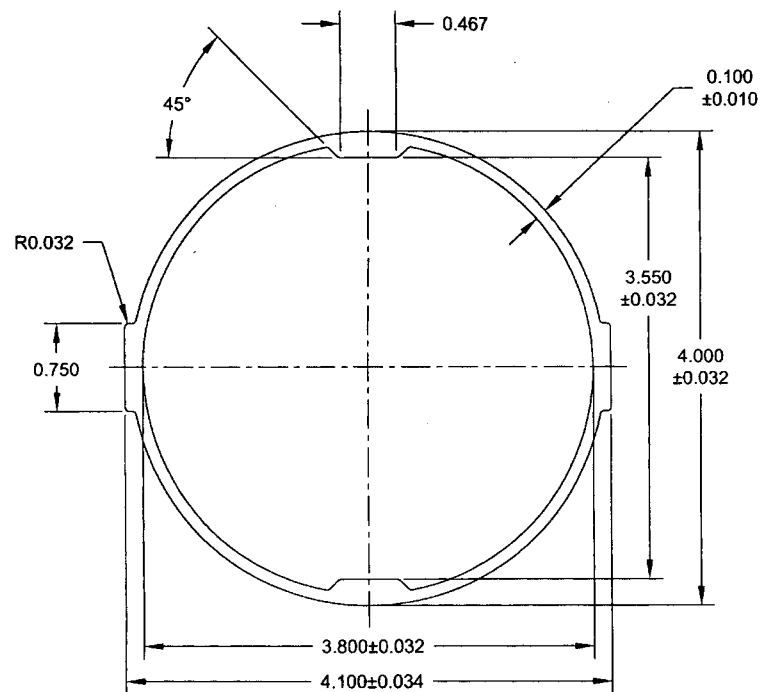
H	REDRAW & REFORMAT DWG: CORRECT BON L DIE # TYP0 (ZN B8-1), ADD AMS & ASTM MATL OPTION (ZN D8-1). TOLERANCES NOW PER CARADON DWG (SHT 2)	CP	09.07.16
G	ADD DIE NUMBERS & 'DIMS IN INCHES' NOTES	PH	07.04.17
F	CHANGE MAT. TO 6061-T6	DS	97.09.29
E	CHANGE MATERIAL TEMPER	DS	96.10.24
D	ADD MATERIAL PROPERTIES	DS	96.10.07
C	ADD D2500-3 WEB	BW	96.04.26
B	CHANGE INTERNAL WEB	DS	96.03.24
A	NEW ISSUE	DS	96.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

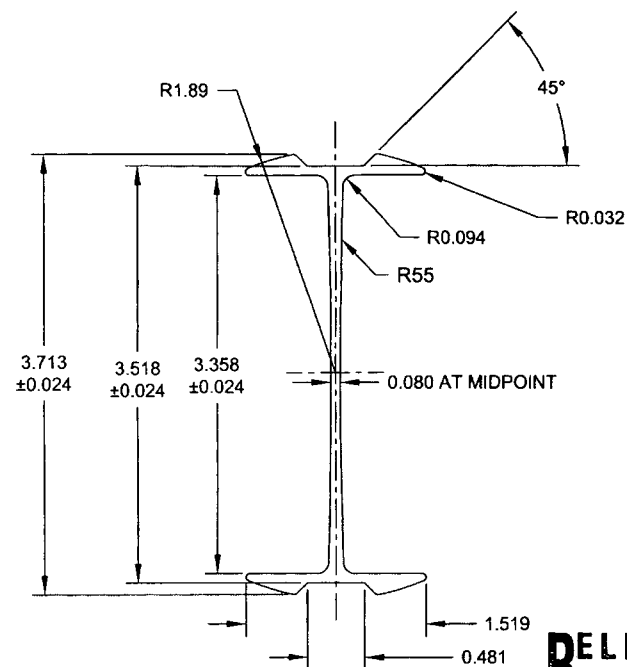
DRAWING NO. D2500 REV. H
SHEET 1 OF 2
TITLE EXTRUSION SCALE NTS

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8 7 6 5 4 3 2 1



D2500-1



D2500-3

RELEASED
2010-02-02
MP

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2500	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EXTRUSION	NTS
DATE	09.07.16	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31027**

Purchase Order Date 1/15/2016

PO Print Date 1/15/2016

Page Number 1 of 2

134536

Order From :
SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

VC-BON001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905-427-6550	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
Ship Via:	Yours ppd	FOB	Destination-Collect
Ship Acct:			

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D2500-1-190P	Ext'N -T Beam Tube 4"	3/29/2016		82.00	\$86.68	\$7,107.76
			Yes		Each		
			3/29/2016				

EXTRUDE AS PER DWG D2500 REV. H
B140538

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE
MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS

Rec'd 9/18

Sp 16-03-22

Line Total: \$7,107.76

2	D2622-120CP	Extrusion	3/29/2016		120.00	\$35.52	\$4,262.40
			Yes		Each		
			3/29/2016				

EXTRUDE AS PER DWG D2622 REV. C
B140539

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE
MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS

Line Total: \$4,262.40

Note:

1/15/2016



1850 Clements Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.comSIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

ACCT# 46024

SHIP TO / EXPÉDIÉ À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200				SOLD TO / VENDUE À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200				TERMS / FREIGHT PP		REFER TO THESE NUMBERS ON ALL CORRESPONDANCE REFEREZ-VOUS A CES NUMEROUS POUR TOUTE CORRESPONDANCE		PACKING LIST DATE / DATE DU 03-21-16			
CUSTOMER ID / ID DU CLIENT 46024				ORDER DATE / DE LA COM 01/15/16		CUSTOMER PO NUMBER / CLIENT PO Nombre PO31027				JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU		SALES REP / REP. DES VENTES R. BLAIS	
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 025233				CARRIER / TRANSPORTEUR MCGILLION				SALES ORDER NUMBER / N° DE COM 122086		SALES REP / REP. DES VENTES R. BLAIS		CUST SERVICE REP / REP. SERVICE CLIENTELE M2A			
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison				
001	2,198	LB		DAA-897105-2	6061 T6		4	2,465	2,306	LB					
	997	KG		D2500-1-190	190.0000 IN			1,118	1,046	KG					
	82	PC								91	PC				
Cut(+): 0.1180 Cut(-): 0.0000 Min: -10 % Max: 10 %															
						861169 / 300677	1	622	582		23 PC				
						861169 / 300678	1	622	582		23 PC				
						861169 / 300679	1	622	582		23 PC				
						861169 / 300680	1	600	560		22 PC				

SP/6-03-22

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the applicable standards set of 1992 as amended. Orders presented subject to the terms and conditions stated on the reverse side.

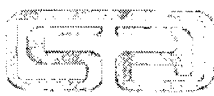
CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

		Continued	
TOTALS			



signature
aluminum
CANADA INC.

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
03/17/2016	5380871	122086	1
Cust PO	B/L No.	Lot	Date
PO31027	025233	861169	03/21/16

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897105-2	190" Mill 6061 T6	D2500-1-190
Gross Weight	2,465 LBS		
Net Qty	2,306 LBS	91 PCS	4 PKGS
Specification	AMS-QQ-A-200/8 & ASTM B221-08		
	Die Desc		

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
306.2 / 44.4	262.8 / 38.1	8.3	N/A	90

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.63	0.26	0.22	0.06	0.88	0.07	0.09	0.02	0.01	0.00

81603/22

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc



ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2001-190
DATE: 2016/03/23

PO / BATCH NO.: B3140538/
PO# 31027

MATERIAL CERT REC'D: YES
QUANTITY RECEIVED: 91 PCS
QUANTITY INSPECTED: _____
QUANTITY REJECTED: _____

THICKNESS ORDERED: _____
THICKNESS RECEIVED: _____
SHEET SIZE ORDERED: _____
SHEET SIZE RECEIVED: _____

* Extrusion

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒	
CORRECT FINISH	☒	N	
CORROSION	Y	☒	
CORRECT GRAIN DIRECTION	☒	N	
CORRECT MATERIAL	☒	N	6061T6
CORRECT THICKNESS	Y	N	inspection sheet attached
PHOTO REQUIRED	Y	N	
CORRECT MATERIAL	☒	N	AMS-QQ-A-200/8
CORRECT REF # TO LINK CERT	☒	N	PO# 31027
CORRECT MATERIAL IDENTIFICATION	Y	N	
CORRECT M# ON THE MATERIAL	Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	☒	N	inspection sheet attached

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	16
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>D</u>	SIGNED OFF BY: <u>MA</u>
DATE: <u>16/05/15</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER

